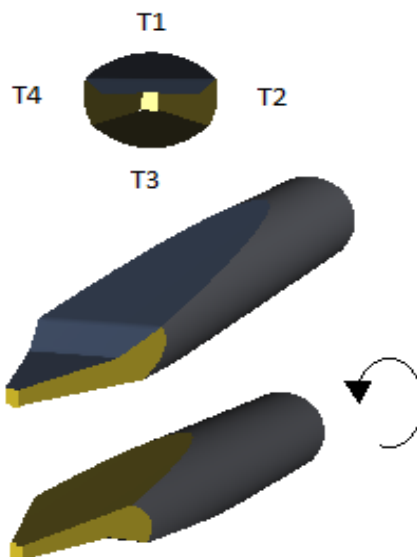



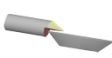
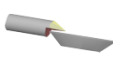
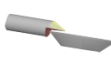
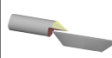
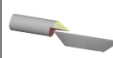
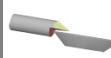






Wire bond tool Ø3.172

A30-200

Wire bond tools are ground with application number A02. Different layers define the shape of each face. In this case, there are three individually layer one for tooth 1, tooth 2+4 and tooth 3. To reach a high precision, all faces are preground with several hundredths overmeasure and are finished with a polish wheel.



1. Cycletime for Production

Workpiece:	E1011-003-FMZ, diameter 1/16", 4 faces						
Material	CARBIDE						
Operations							
Feed [mm/Min]	2000	30	60	40	40	60	40
Power [kW]		1	1	1	1	1	1
Cutting speed [m/s]		24	24	22	22	24	22
Used wheels							
Grinding time [s]	33	56	24	45	35	32	44
Total cycle time	4 Min 29						

The cycle times are indicative. Material to be ground, grinding wheels, coolants can influence the cycle times considerably.

2. Used Grinding Wheels

1	11V9 Ø100 D76
2	11V9 Ø75 D46



1

2

3. Machine and Software Requirements

Machines: 5 axes CNC grinders : NORMA CFG

Control: Fanuc 31i

Accessories:

Responsible engineer: KIG 27.11.2013

Coolant: Synthetic Oil, pressure 6 bar

Software: Quinto 5

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